



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2151

Job Sheet 175746



Part No: D2151

Job Qty: 20 ea

Part Name: Packer Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP C 00.10.23 Re-format (mpp 2101) EC IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
IPP Rev:E 06-11-24 As per Rev B JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	4/23/18	4/23/18	0.00	0.00	Start Up Waterjet		SL 18/04/24
100	Waterjet	20 pcs	4/23/18	4/23/18	0.00	0.69	Waterjet1		SL 18/04/24
120	QC	20 pcs	4/23/18	4/23/18	0.00	0.00	QC8		38
130	Small Fab	20 pcs	4/23/18	4/23/18	0.00	0.00	Small Fab 1	N14	9-80
140	HandFinish	20 pcs	4/23/18	4/23/18	0.00	0.30	HandFinish1		SA 18-05-01
150	Powdercoat	20 pcs	4/24/18	4/24/18	0.00	0.19	Powdercoat1		BR 18-5-03
160	QC	20 pcs	4/24/18	4/24/18	0.00	0.00	QC3		MAY 04 2018
170	Packaging	20 pcs	4/24/18	4/24/18	0.00	0.00	Packaging3-1	St 002	MAY 11 2018
180	QC21-SA	20 Ea	4/24/18	4/24/18	0.00	0.00	QC21		18/05/14

Part Op 100 - 1-Cut as per Dwg D2151

Descriptions: 130 - Deburr

150 - START TIME: 1:30

FINISH TIME: 2:00 O.T.: 300° M 138760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	.7000 sf (.035 ea)	90-Start up Operation	S052051

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	1	219	0



Container No: S064788



Part: D2151

Job No: 175746

Serial No/Batch: S064788

Revision:

Inspector:

Dart Aerospace Ltd.
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CANADA
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Date: 04/24/18

100
↓
002

32
20

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Packer	0.098Inches + 0.005 - 0.000	0.103 0.098	0,099	Diameter
2	Packer	0.171Inches + 0.005 - 0.000	0.176 0.171	0,173	Diameter
3	Packer	0.231Inches ± 0.010	0.241 0.221	0,230	
4	Packer	1.217Inches ± 0.010	1.227 1.207	1,219	
5	Packer	2.194Inches ± 0.010	2.204 2.184	2,193	
6	Packer	2.300Inches ± 0.010	2.310 2.290	2,298	
7	Packer	1.560Inches ± 0.010	1.570 1.550	1,555	
8	Packer	0.250Inches ± 0.010	0.260 0.240	0,247	
9	Packer	1.328Inches ± 0.010	1.338 1.318	1,328	
10	Packer	0.342Inches ± 0.010	0.352 0.332	0,346	
11	Packer	0.740Inches ± 0.010	0.750 0.730	0,744	
12	Packer	2.050Inches ± 0.010	2.060 2.040	2,049	
13	Packer	0.040Inches ± 0.010	0.050 0.030	0,040	

Plex 4/10/18 2:00 PM Dart.Gagnon.Michelle